

Date: Monday, 11/05/2009 1:20:57 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HINGE
<b>Job Number</b> : 47845	
<b>Estimate Number</b> : 11555	
<b>P.O. Number</b> :	<b>Part Number</b> : D30811
<b>This Issue</b> : 11/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3081 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44081	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 22/05/2009 <b>Qty:</b> <del>6</del> Um: Each
<b>Checked &amp; Approved By</b> : <u>JUD 09-05-11</u>	
<b>Comment</b> : Est A 02.04.26 New Issue NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MS2025757200	Piano Hinge
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**Comment:** Qty.: 0.3333 Each(s)/Unit Total : 1.9998 Each(s)

HINGE

Pick:

Qty	Part number	Description	Batch
1	MS20257-5	Continuous hinge 6ft	<u>M101041</u>

Ep09/05/14

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Cut hinge as per dwg (approx 26 pieces) and drill as per dwg D3081.

Deburr.

Bend hinge as per dwg D3081.

Ep09/05/14 (X6) (X6)

SB 09/06/09 (X6)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SB 09/06/09 (X6)

4.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Break hinges immediately after powder coat.

START TIME: 9:00amOVEN TEMPERATURE: 400°FFINISH TIME: 9:30am

SB 09-06-10 (X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 47845

Part Number: D30811

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pa 09/06/10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(6)

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 62

9/6/10

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf  
09-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

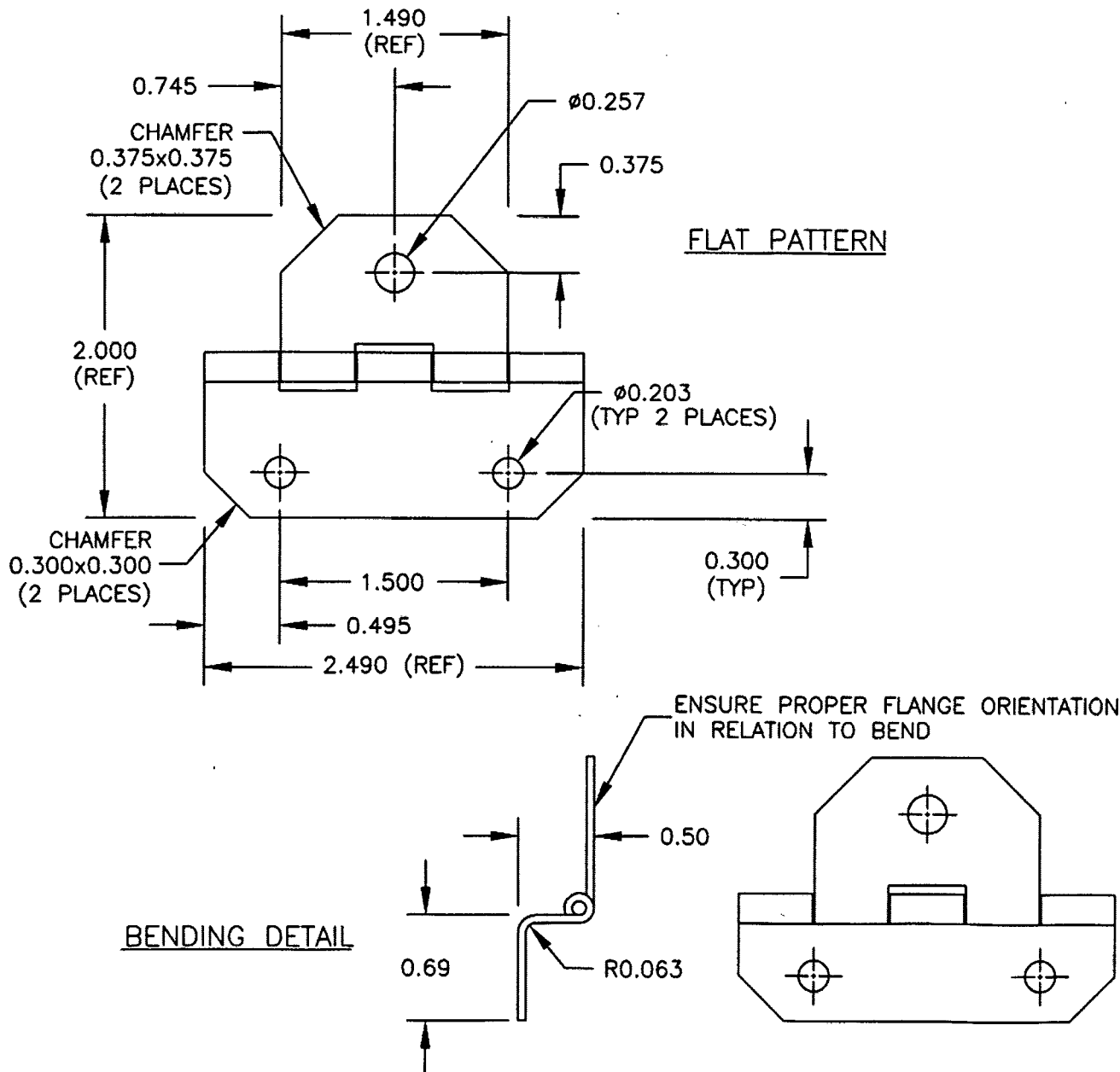
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3081	REV. A SHEET 1 OF 1
DATE 02.01.18		TITLE HINGE	SCALE 1:1
A	02.01.18	NEW ISSUE	



#### D3081-1 HINGE

MAKE FROM MS20257-5 CONTINUOUS HINGE

BREAK SHARP EDGES 0.015 MAX

FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
02.01.25  
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WORK ORDER

NO. 47845